

Mint of the United States at Philadelphia, Pa.,
Machine Shop
~~SUPERINTENDENT'S OFFICE,~~

October 2nd, 1883.
Hon. A. London Snowden

Sir,

As the hobs used in making the knurls, for knurling the periphery of the gold and silver coin collars, are so worn as to be unfit for further use; it will be necessary to prepare new hobs. This I believe can best be done here, if you will allow cutters to be made by Brown & Sharpe, to suit their milling machine.

There are two hobs, one having forty ribs or teeth to the inch, and the other fifty to the inch; under the present method of knurling collars, it is not possible that each collar of a particular coin shall contain the same number of ribs or teeth. If wheels are provided for the milling machine

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we may be able to make tools to overcome this difficulty, if you deem it advisable. For instance The Silver Dollar with a circumferential line of $4\frac{1}{2}$ " should have 108 ribs or teeth, and The Dime with a circumferential line of $2\frac{1}{2}$ " should have 110 ribs,

The plan of knurling the collars with a punch is not new, having been in use at New-Orleans for years. The punches are made to correspond to the exact diameters of the coins, and are forced into the collars, making them uniform, as to size and number of ribs. I would be obliged if you will have one old punch of this description, sent for as a pattern. Will you be kind enough

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to let me know if the cutters as before
mentioned can be ordered from Brown &
Sharpe, through Mr Watson, or direct on
the manufacturer,

Very Respectfully
David James
Graham

996

Mint of the United States at Philadelphia, Pa.,

~~SUPERINTENDENT'S OFFICE,~~

Oct 21, 1883

Saml James

~~Superintendent,~~

Foreman Machine Shop

a few hobs needed
for mauling the
periphery of collars.

No. of Enclosures,



Mint of the United States at Philadelphia, Pa.
Machine Shop.

October 2, 1883

Hon. A. Loudoun Snowden

Sir:

As the hubs used in making the knurls, for knurling the periphery of the gold and silver coin collars, are so worn as to be unfit for further use; it will be necessary to prepare new hubs. This I believe can best be done here, if you will allow cutters to be made by Brown & Sharpe, to suit their milling machine.

There are two hubs, one having forty ribs, or teeth, to the inch, and the other fifty to the inch; under the present method of knurling collars, it is not possible that each collar of a particular coin shall contain the same number of ribs or teeth. If wheels are provided for the milling machine we may be able to make tools to overcome this difficulty, if you deem it advisable. For instance, the Silver Dollar with a circumferential line of 4.7124-inch should have 188 ribs or teeth, and the Dime with a circumferential line of 2.700-inch should have 110 ribs.

The plan of knurling the collars with a punch [ed – called a ‘drift tool’] is not new, having been in use at New Orleans for years. The punches are made to correspond to the exact diameters of the coins, and are forced into the collars, making them uniform, as to size and number of ribs. I would be obliged if you will have an old punch of this description, sent for as a pattern. Will you be kind enough to let me know if the cutters as before mentioned can be ordered from Brown & Sharpe, through Mr. Watson, or direct on the manufacturer.

Very respectfully, Samuel
James Foreman [of machinists]